

Work Order ID 82714

82714

April-05-12 11:20:22 AM

Item ID: D135-751-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube Installation

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12/04/05 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011-04G001

SCRAP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D135-751-011 PAR #: _____ Fault Category: Landing Gear / SKID NCR: Yes No DQA: 12/04/12 Date: 12/04/16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/04/16 Date: 12/04/16

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 1125.68						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.04.12	120	SECTION E-E hole drilled on bottom surface instead of top. Rc. LOA envelope didn't read Drawing	CP 12.04.12 Q51042	SCRAP. WELD REPAIRS NOT PERMITTED IN THAT AREA OF SKID. NO Replace	12.04.12	12-4-12	CP 12.04.12 Q51042	5 relax/12
12.04.12				SCRAP DRILL HOLE NOT IN THE RIGHT PLACE	12.04.12	12-4-12		

NOTE: Date & initial all entries

Work Order ID 82714***82714***

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April-05-12 11:20:22 AM

Item ID: D135-751-011

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Installation

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Cut Aft end as per dwg D3507.

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Setup Start

NS1

Revision ID:

Item Name: Skidtube Installation

Stop

NS2

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00

170

Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.
and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: _____
Exp Date: _____
start time : _____
end time: _____

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: _____

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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82714

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N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 05/04/2012 **Start Qty:** 1.00 ***1***

Required Date: 17/04/2012 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180*	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							
190 *190*	Skidtubes	0.00							
Skidtubes Skidtubes	Memo	0.00							
	1-Rivet D3506-1/-3 as per Dwg D3507.								
200 *200*	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Quality Control.

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-05-12 11:20:22 AM

Item ID: D135-751-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Installation

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

0.00

260

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: _____
Exp Date: _____

3-Install Wearplates as per Dwg D3507 ,

Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg(Note #6)A/R 241 Sika Flex Batch: _____
Exp Date: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: _____

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: _____

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 05/04/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 17/04/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

270

270

QC

Quality Control

Operation	Description
QC5-	Inspect part completeness to step on W/O

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool

Plan Code

Accept
Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

280

280

Packaging

Packaging

Pick Kit	0.00
----------	------

Memo

0.00

0.00

290

290

QC

Quality Control

QC4- 100% Inspect kits for completeness	0.00
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Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Skidtube Installation

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

112-0412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-05-12 11:20:26 AM

Page 1

Work Order ID: 82714

82714

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:
 IPP Rev:A06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased		No			Each	318.0000		38			

AI S7-1032-130

Insert

Location	Loc Qty	Loc Code
ST280	165	
117717	27	
118966	22	
119775	116	
ST282	153	
119530	73	
120181	80	

D3507-1-BENT

Manufactured No

120 Each

7.0000

1

D3507-1-BENT

Skidtube Assembly EC135

① 12-04-12

Location	Loc Qty	Loc Code
LG	7	
75264	2	
75265	2	
77441	1	
77443	2	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-05-12 11:20:26 AM

Work Order ID: 82714

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

82714

D135-751-011

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3504-1	Manufactured	No	170	Each	21.0000	2	2
---------	--------------	----	-----	------	---------	---	---

D3504-1

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	21	
53742	2	
75240	19	

D3504-3	Manufactured	No	170	Each	11.0000	1	1
---------	--------------	----	-----	------	---------	---	---

D3504-3

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	11	
53743	11	

D3504-5	Manufactured	No	170	Each	15.0000	2	2
---------	--------------	----	-----	------	---------	---	---

D3504-5

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	15	
76239	15	

D3505-1	Manufactured	No	170	Each	3.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D3505-1

Web

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	2	
75256	2	
LG001	1	
75211	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82714

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3506-1	Manufactured	No	190	Each	44.0000	4	4
---------	--------------	----	-----	------	---------	---	---

D3506-1

Doubler

Location

Loc Qty

Loc Code

ST051

44

74733

8

75090

36

D3506-3	Manufactured	No	190	Each	57.0000	2	2
---------	--------------	----	-----	------	---------	---	---

D3506-3

Doubler

Location

Loc Qty

Loc Code

ST051

57

51790

57

MS20601-AD4W3	Purchased	No	190	Each	2,172.000	12	12
---------------	-----------	----	-----	------	-----------	----	----

MS20601-AD4W3

Rivet

Location

Loc Qty

Loc Code

ST321

2172

114538

2172

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

260

Each

2,469.000

1

1

AI S4-1032-225

Insert

Location

Loc Qty

Loc Code

ST281

2446

108696

146

110768

62

118386

55

118966

68

120671

115

121269

2000

ST282

23

120410

10

120451

13

AN3C4A

Purchased

No

260

Each

3,020.000

31

31

AN3C4A

BOLT

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

120769

38

121205

1000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D135-751-011

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

260 Each 1,600.000 2 2

AN3C5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7	
115835	7	
ST350	1593	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	520	
1210168	500	
121255	500	

AN526C1032R10 Purchased No

260 Each 219.0000 2 2

AN526C1032R10

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	79	
108062	79	
ST348	140	
110049	40	
114494	100	

AN960C10L NAS1149C0332 Purchased No

260 Each 0.0000 33 33

***AN960C10L ***

washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2965	Manufactured	No	260	Each	59.0000	1	1
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D2965

Cap, 105 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	59	
71371	9	
80089	50	

D2965-3	Manufactured	No	260	Each	8.0000	1	1
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D2965-3

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	8	
50560	1	
75254	7	

D3492-1	Manufactured	No	260	Each	30.0000	4	4
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D3492-1

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	30	
69531	8	
74444	2	
76235	4	
77037	16	

D3492-3	Manufactured	No	260	Each	1.0000	4	4
---------	--------------	----	-----	------	--------	---	---

D3492-3

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	1	
78600	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-05-12 11:20:26 AM

Page 7

Work Order ID: 82714

82714

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-7

Manufactured No

260

Each

32.0000

2

2

D3492-7

Plug

Location

Loc Qty

Loc Code

FP002

32

71881

8

77222

24

D3508-1

Manufactured No

260

Each

11.0000

1

1

D3508-1

Wearplate

Location

Loc Qty

Loc Code

FP002

11

72933

11

D3508-3

Manufactured No

260

Each

12.0000

1

1

D3508-3

Wearplate

Location

Loc Qty

Loc Code

FP001

12

38527

1

81347

11

D3508-5

Manufactured No

260

Each

15.0000

1

1

D3508-5

Wearplate

Location

Loc Qty

Loc Code

FP001

15

71688

6

72416

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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April-05-12 11:20:26 AM

Page 8

Work Order ID: 82714

82714

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-7 Manufactured No

260

Each

12.0000

1

1

D3508-7

Wearplate

Location

Loc Qty

Loc Code

FP001

12

76265

12

D3558-1 Manufactured No

260

Each

9.0000

1

1

D3558-1

Gasket

Location

Loc Qty

Loc Code

FP002

9

50925

1

73561

8

D3558-3 Manufactured No

260

Each

13.0000

1

1

D3558-3

Gasket

Location

Loc Qty

Loc Code

FP

12

82312

12

FP002

1

71651

1

D3558-5 Manufactured No

260

Each

11.0000

1

1

D3558-5

Gasket

Location

Loc Qty

Loc Code

FP002

11

75255

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

April-05-12 11:20:26 AM

Page 9

Work Order ID: 82714

82714

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-7

Manufactured No

260

Each

9.0000

1

1

D3558-7

Gasket

Location

Loc Qty

Loc Code

FP002

9

75249

9

NAS1611-007

Purchased

No

260

Each

264.0000

2

2

NAS1611-007

O-RING

Location

Loc Qty

Loc Code

FP001

264

103697

264

NAS1611-010

Purchased

No

260

Each

259.0000

4

4

NAS1611-010

O-RING

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-05-12 11:20:26 AM

Page 10

Work Order ID: 82714

82714

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 05/04/2012

Required Date: 17/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

250.0000

4

4

NAS1611-013

O-RING

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

AN3C4A

Purchased

No

280

Each

3,020.000

8

8

AN3C4A

BOLT

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

120769

38

121205

1000

AN960C10L

NAS1149C0332

Purchased

No

280

Each

0.0000

8

8

***AN960C10L ***

washer

D3512-1

Manufactured

No

280

Each

5.0000

2

2

D3512-1

Wearplate

Location

Loc Qty

Loc Code

ST500

5

74735

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

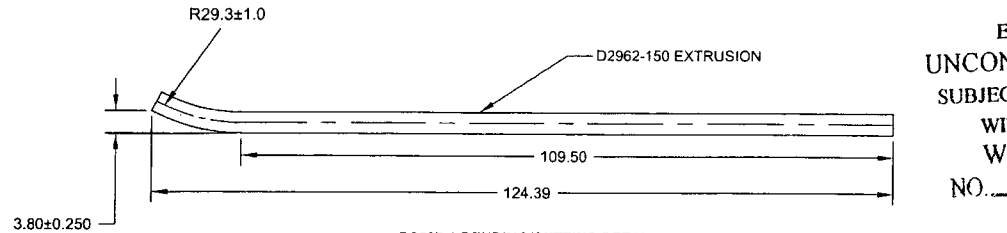
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82714 MLJ
12/04/05

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

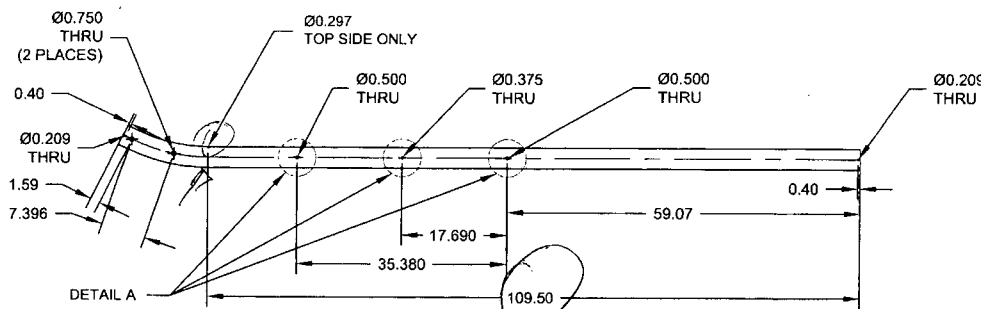
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

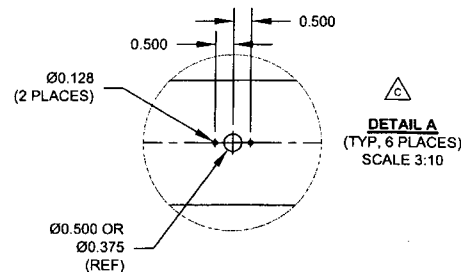
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JTC	PORT HADLOCK, WA	
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

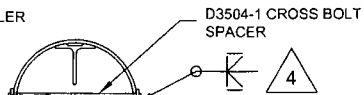
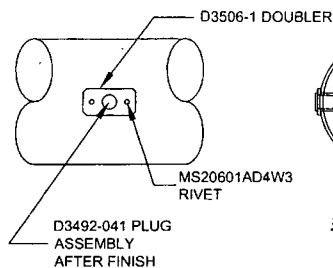
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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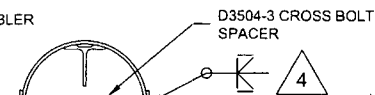
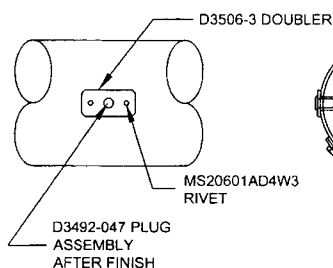
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



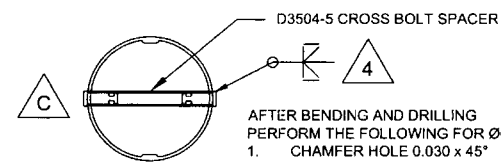
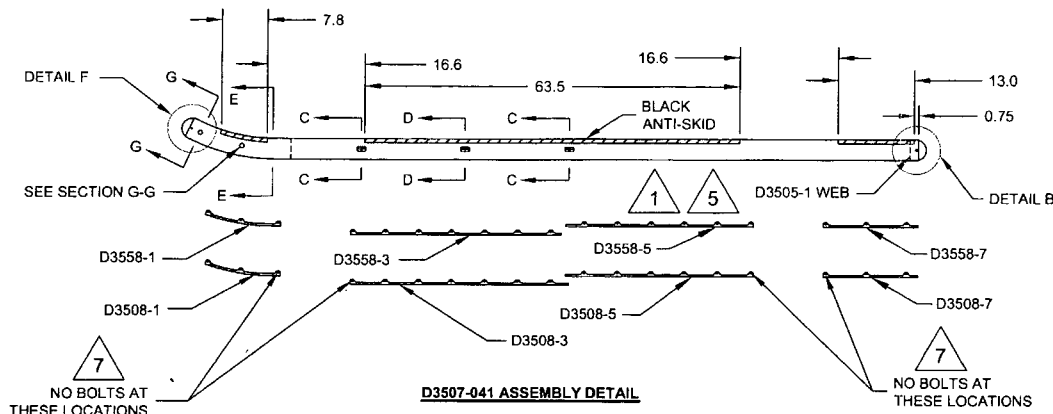
SECTION C-C
(SCALE 3:10)

- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



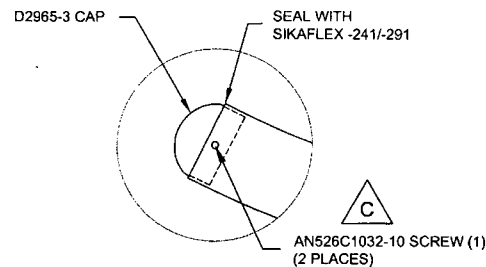
SECTION D-D
(SCALE 3:10)

- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)

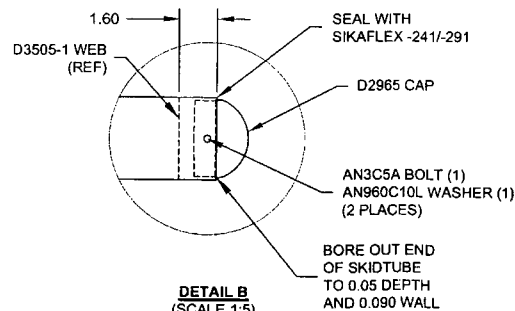


SECTION G-G
(SCALE 3:10)

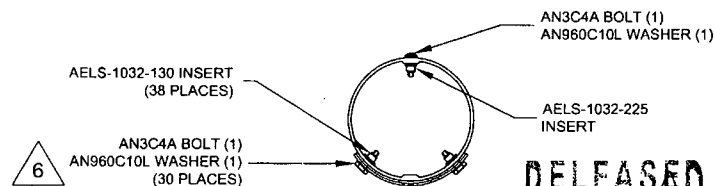
- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



DETAIL F
(SCALE 1:5)



DETAIL B
(SCALE 1:5)



SECTION E-E
(SCALE 3:10)

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	CE	D3507	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	
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RELEASED
07-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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